



Solid carbide high performance drill Whistle-Notch shank DIN 6535 HE, TiN, Ø DC h7: 12 mm



Order data

Order number	123308 12
GTIN	4045197451392
Item class	12E

Description

Version:

Strong core and special point geometry ensure the cutting chisel edges maintain **high self-centring accuracy**.

Straight cutting edges with slight edge hone and a special flute profile produce **short chips**.

Recommendation:

Maximum drilling depth:

clamping slot length (see table) less 1.5×nominal Ø.

Note:

Flute length $L_c = L_2 + 1.5 \times D_c$.

For process reliability when using the 12×D deep-hole drill, an initial centre drilling with No. 121068 – 121130 or 3×D pilot drilling operation with No. 122736 is necessary.

Pilot drill required: yes, pilot drill

Standard: Manufacturer's standard

Tolerance nominal Ø: h7

Number of cutting edges Z: 2

Tolerance nominal Ø: h7

recommended maximum drilling depth L_2 : 138 mm

Overall length L: 204 mm

Shank Ø D_s : 12 mm

Feed f in steel < 1100 N/mm²: 0.26 mm/rev.

Technical description

Feed f in steel < 1100 N/mm ²	0.26 mm/rev.
Flute length L_c	156 mm

Shank tolerance	h6
Nominal $\varnothing D_c$	12 mm
Number of cutting edges Z	2
Tolerance nominal \varnothing	h7
Shank $\varnothing D_s$	12 mm
Overall length L	204 mm
Standard	Manufacturer's standard
recommended maximum drilling depth L_2	138 mm
Coating	TiN
Tool material	Solid carbide
Drill depth up to	12xD
Point angle	135 degrees
Shank	DIN 6535 HE to h6
Through-coolant	yes, with 25 bar
Pilot drill required	yes, pilot drill
Colour ring	green
Type of product	Jobber drill